

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action . Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 73603

Wednesday, September 07, 2011 10:44:09 A



Item ID: D3121-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 9/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location: <u>235</u> | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |

11/9/8

sf (200)

11/9/8

19ME
11-09-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 10:44:04 AM

Page 1

Work Order ID: 73603



Parent Item: D3121-25



Parent Item Name: Cap


Start Date: 9/8/2011

Required Date: 9/8/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-05-10 JLM
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MDELNR1.2500  | | Purchased | | | No | 100 | f | 14.4680 | 0.052 | 1.094737 | | | |
| DELRIN ROUND BAR 1.25" | | | | | | | | | | | | | |



Re 11.9.8

Location

MAT055

114586 ✓

Loc Qty

14.468

14.468

Loc Code

1.668

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

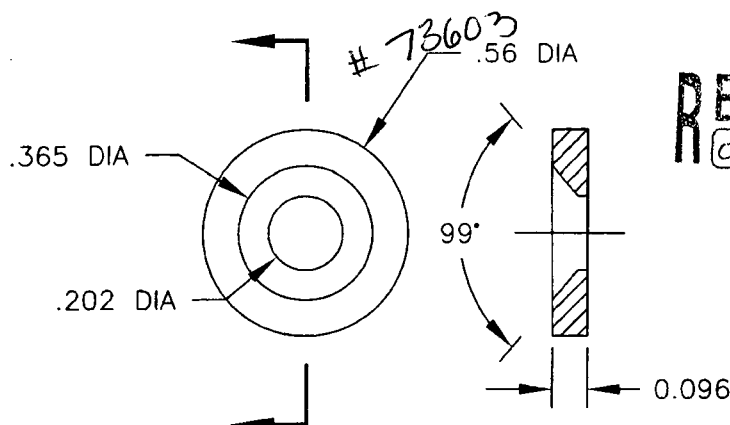
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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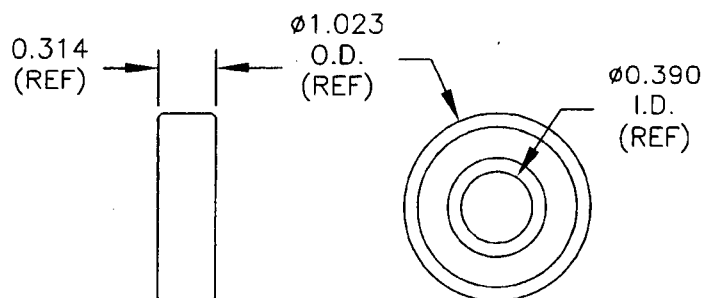
NOTE: Date & initial all entries

DART

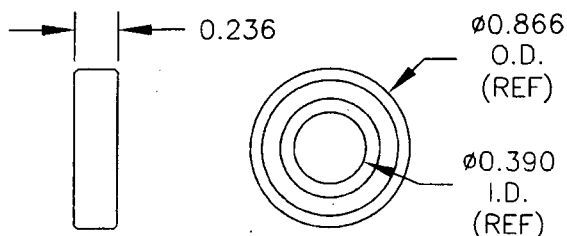
| | | | |
|------------------|---------------------------|---|--------------------------|
| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 10 OF 10 |
| DATE 07.11.07 | TITLE BRACKET ASSEMBLY | | SCALE 1:1 |

**D3121-17 WASHER (SCALE 2:1)**

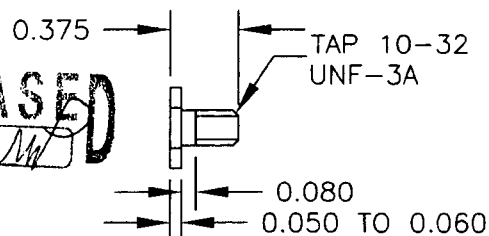
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

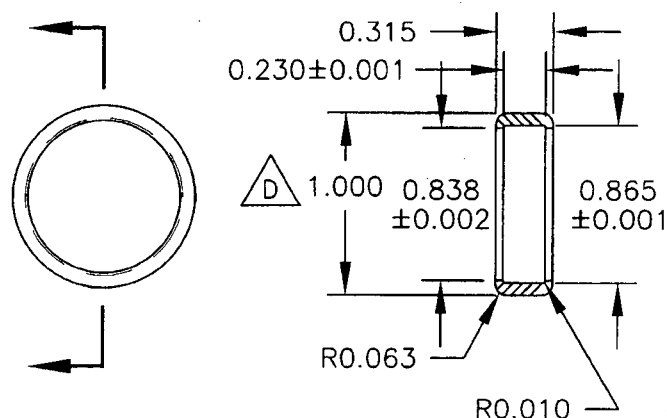
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

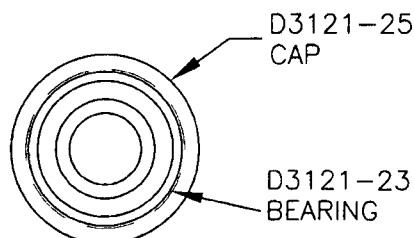
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.11.07 MW**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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NOTE: Date & initial all entries

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|-----------------------|--------|-----------------------|
| DART AEROSPACE LTD | | Work Order: 73603 |
| Description: Cap | | Part Number: D3121-25 |
| Inspection Dwg: D3121 | Rev: E | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.315 | +/-0.010 | .320 | / | | 20.02 | |
| Ø1.000 | +/-0.010 | 1.000 | / | | CNC-006 | |
| Ø0.838 | +/-0.002 | .839 | / | | | |
| R0.063 | +/-0.010 | R.063 | / | | | |
| R0.010 | +/-0.010 | R.007 | / | | | |
| 0.230 | +/-0.001 | .230 | / | | | |
| Ø0.865 | +/-0.001 | .866 | / | | | |
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|------------------------|------------------------|---------------------|-----|
| Measured by: <i>DR</i> | Audited by: <i>omf</i> | Prototype Approval: | N/A |
| Date: 11.9.8 | Date: 11/09/08 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|-----------|
| A | 04.04.20 | New Issue (P/O D3121-241) | KJ/RF | |
| B | 06.06.09 | Ø1.000 diameter was Ø1.024 | KJ/JLM | |
| C | 08.01.16 | Dwg Rev. updated | KJ/EC/DD | <i>DD</i> |

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